

Date: Tuesday, 16/09/2008 3:28:43 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : AFT BASE ASS'Y *Split*
 Job Number : 42040 *2*
 Estimate Number : 13043
 P.O. Number :
 This Issue : 16/09/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : // Type : SMALL /MED FAB
 Previous Run : 39931
 Written By :
 Checked & Approved By : *JUD 08.9.16*
 Comment : Est Rev:A New Issue 07-09-27 DD verified by: EC
 Est Rev:B ECN 1113P 08-01-22 DD verified by: EC
 Est Rev:C ecn1162 08-04-02 DD verified by: EC

Part Number : D3651041
 Drawing Number : D3651 REV.B
 Project Number : N/A
 Drawing Revision : B
 Material :
 Due Date : 30/10/2008 Qty: *5* Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

2.0 D3651043 Flange Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
 FLANGE ASSEMBLY *B 40856*

FF 08/10/02

3.0 D36511 Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
 GASKET

B 42115 / B35844 SB

4.0 D36519 Inside Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
 DOUBLER

① B 37 138

B 42118

SB

5.0 D36511 Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
 GASKET

B 39938 / B37139 / 42116(x4)

SB 08/11/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 16/09/2008 3:28:43 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BASE ASSY

Job Number: 42040

Part Number: D3651041

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 D365113 Outside Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)
DOUBLER ① B 37140 B42117 ⑤ SB 08/11/25 1

7.0 CR3523402 RIVET



Comment: Qty.: 58.0000 Each(s)/Unit Total: 290.0000 Each(s)
RIVET ~~1106302~~ ⑤ / 1109371 SB 08/11/25 1

8.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: 1-Assemble as per dwg D3651
2- Seal all mating surfaces and gaps using Proseal 700 fire wall sealant as per dwg D3651
Batch: 11109536
3-install D3651-1 using 3M high performance contact adhesive 1357 as per dwg D3651
Batch: 11105623 PF 08/11/25 ④

9.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP SB 08/11/25 ①

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify with Dart part # using a fine point permanent marker and Stock
Location: 6A SB 08/11/25 ①

11.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE 08/11/26 JF

Job Completion



mf 08-11-25

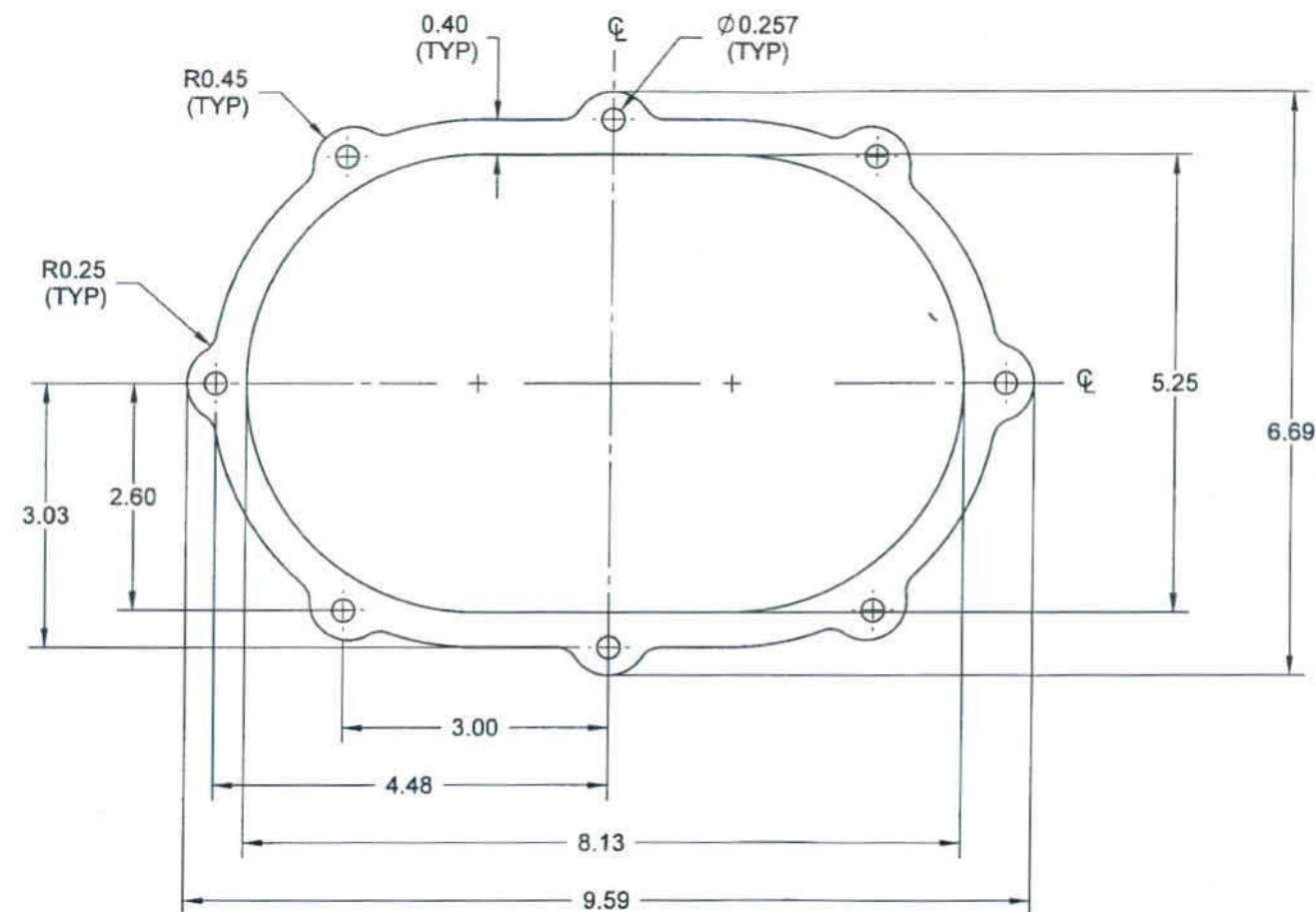
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



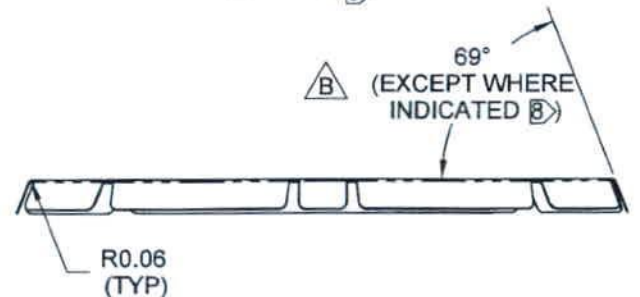
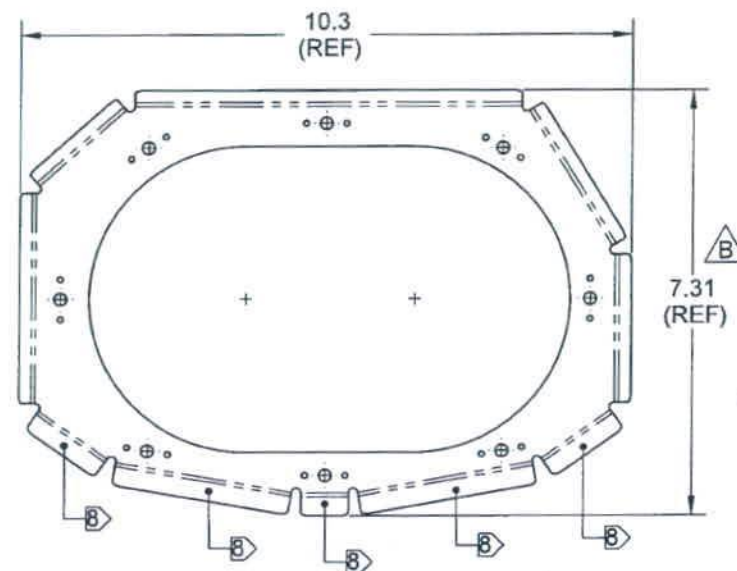
D3651-1 GASKET

NOTES:

- 1) MATERIAL: THERMO-CHEM P/N G-89, (REF. 0.060 THICK)
POSSIBLE SUPPLIER: A.R. THOMSON GROUP
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) PART IS SYMMETRIC ABOUT ϕ
- 8) WEIGHT: 0.09 lbs

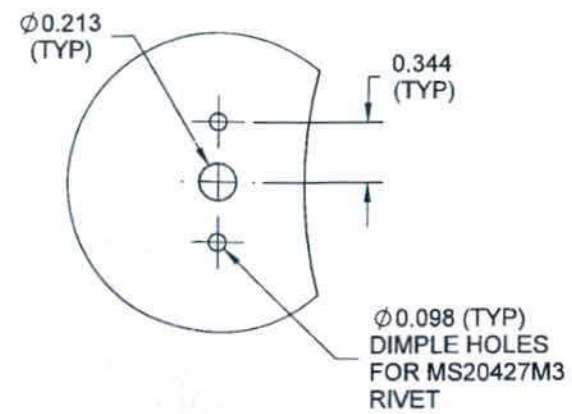
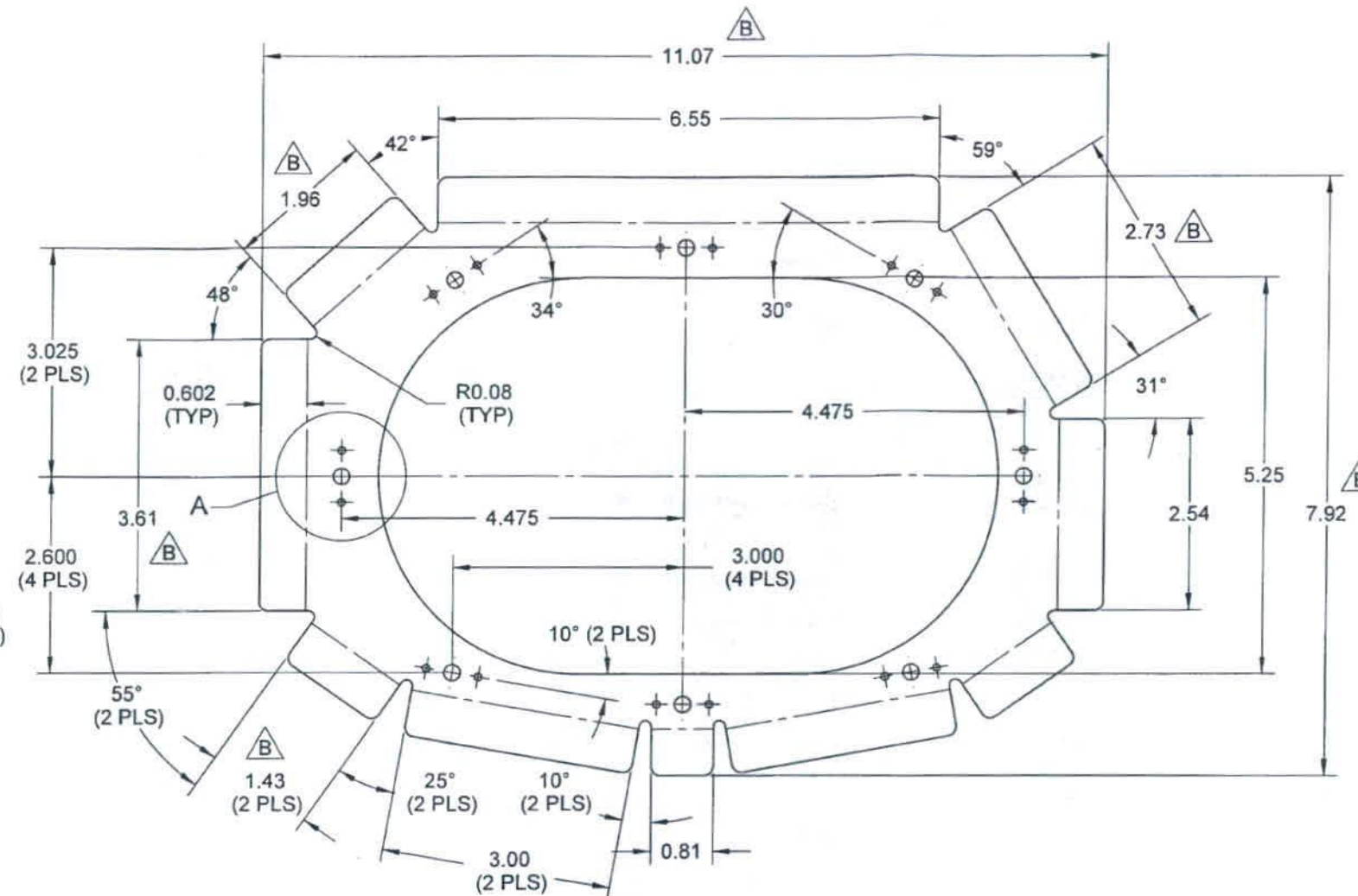
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MFG. APPR.		D3651	SHEET 3 OF 9
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D3651-3 BASE
(MAKE FROM D3651-3F FLAT PATTERN)

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.27 lbs
 - 8) BEND TO 55° WHERE INDICATED

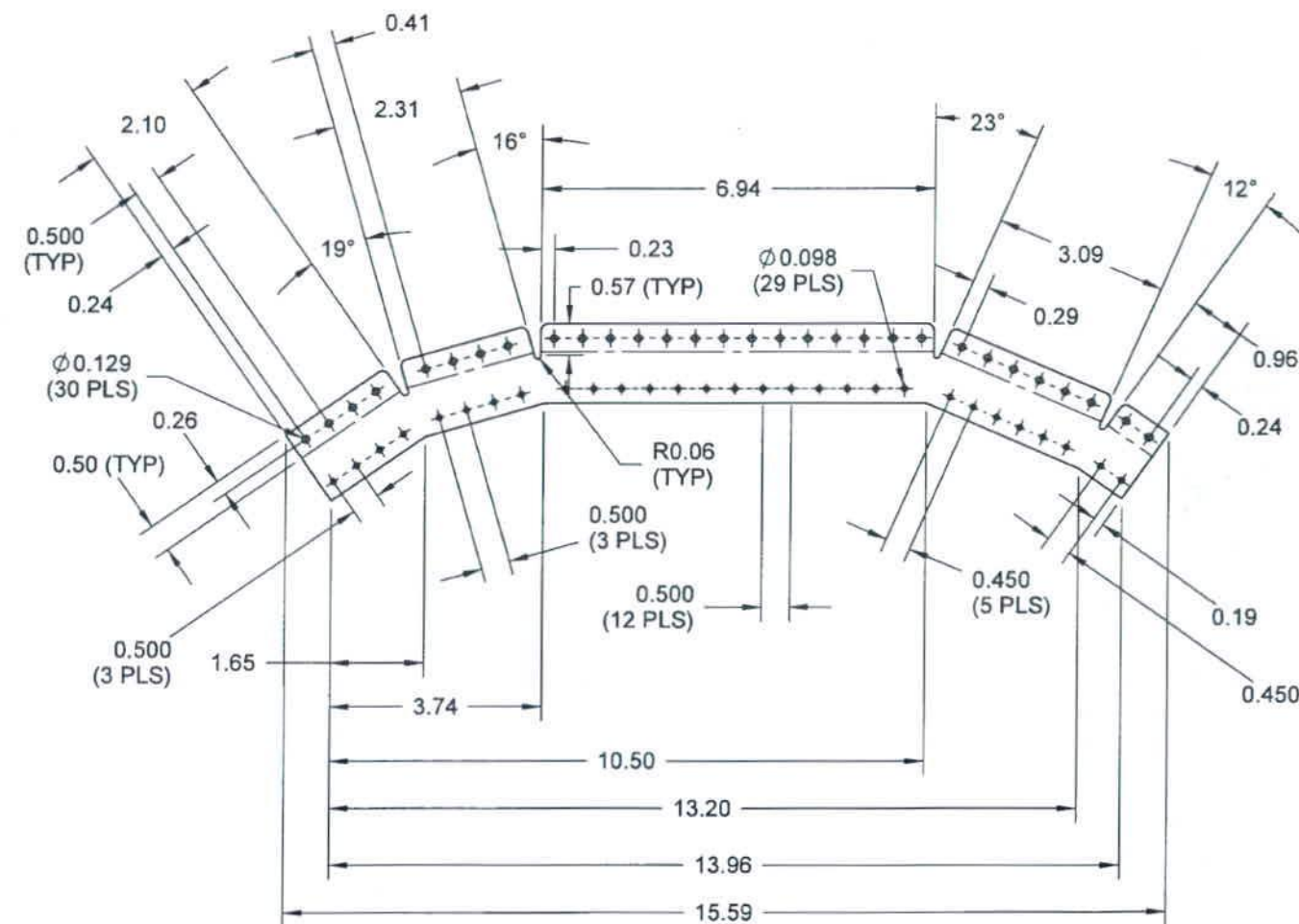


DETAIL A

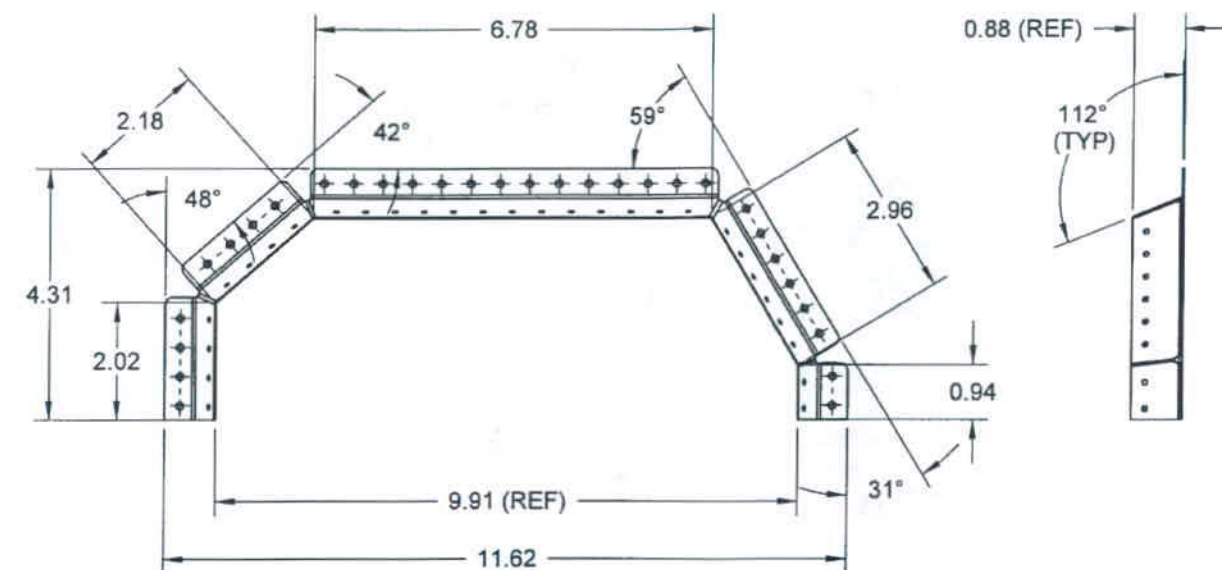
D3651-3F FLAT PATTERN

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D3651-7F FLAT PATTERN



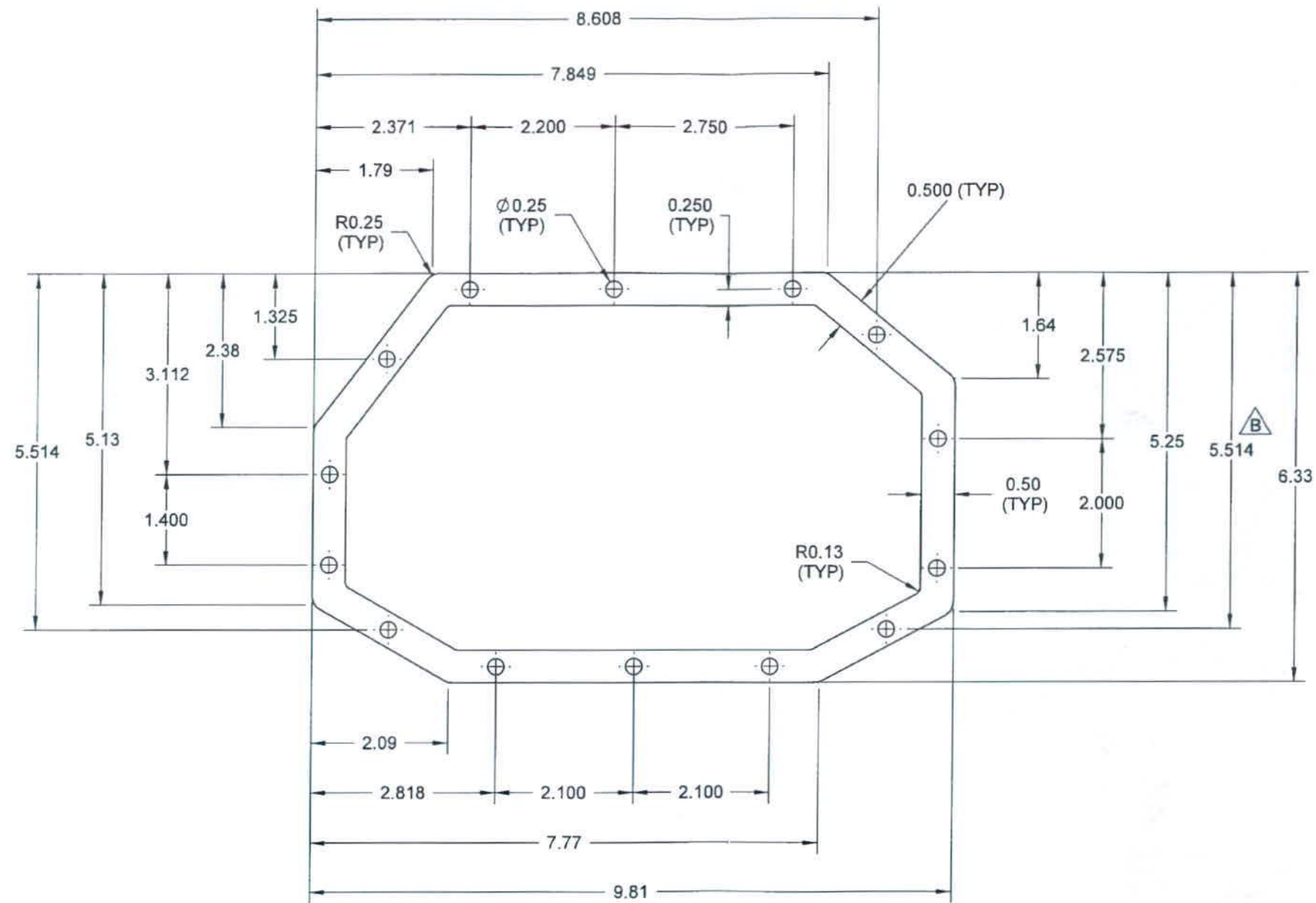
D3651-7 BOTTOM FLANGE BEND DETAIL
(MAKE FROM D3651-7F FLAT PATTERN)

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

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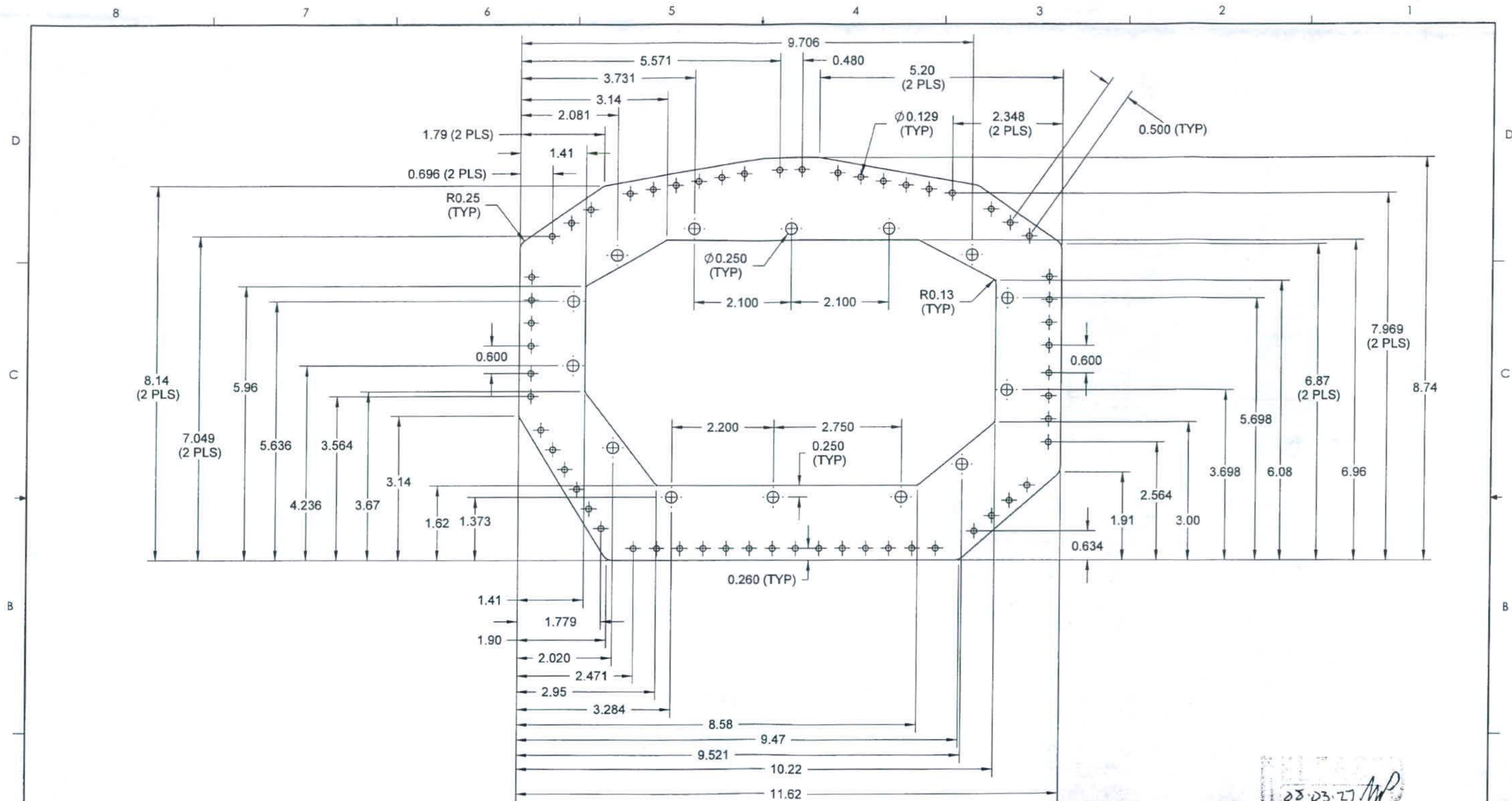
D3651-9 INSIDE DOUBLER

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.07 lbs

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NOTES:

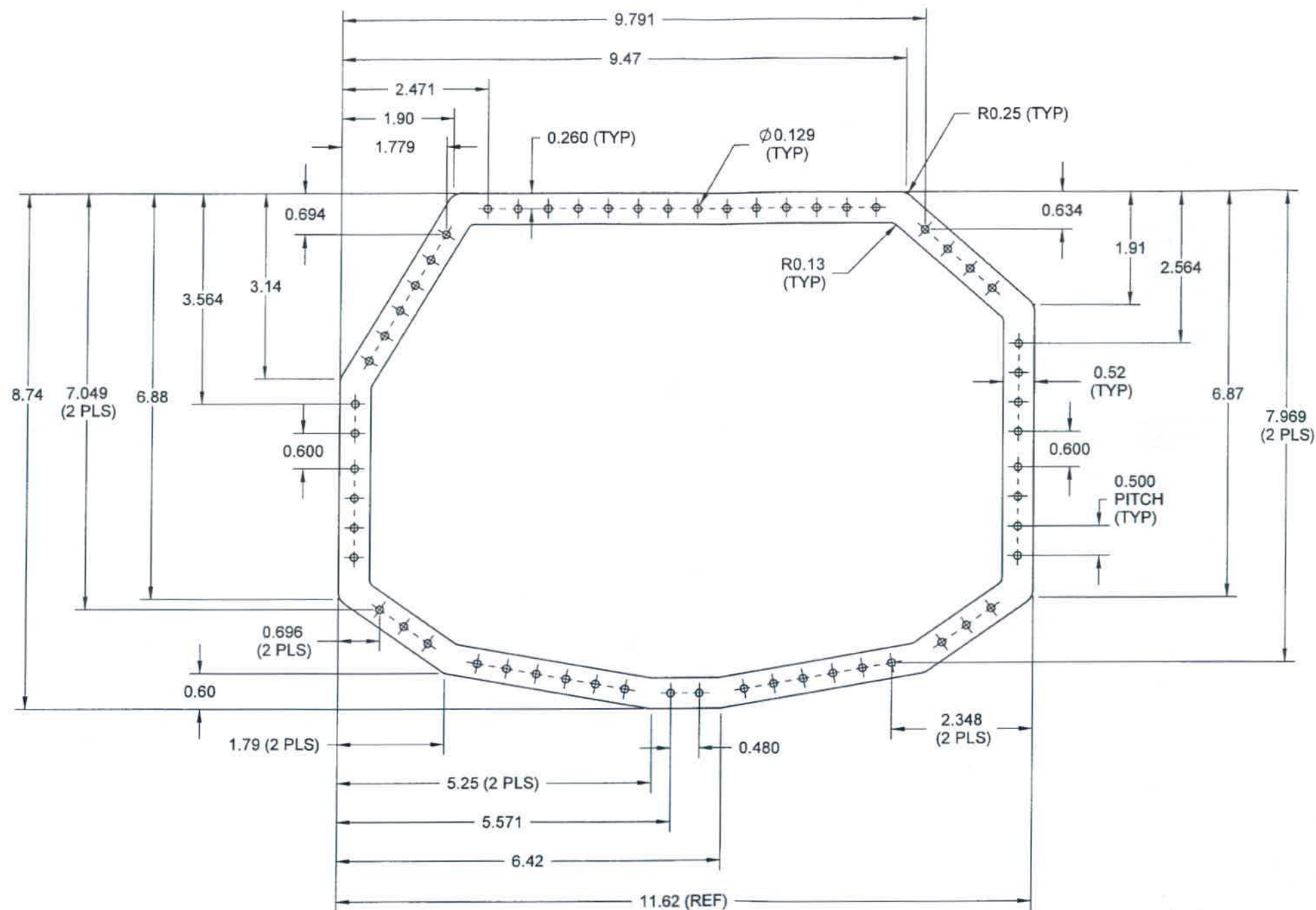
- 1) MATERIAL: THERMO-CHEM P/N G-89, (REF. 0.060 THICK)
POSSIBLE SUPPLIER: A.R. THOMSON GROUP
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.2 lb

D3651-11 GASKET



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D3651-13 OUTSIDE DOUBLER B

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.10 lbs

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